

Work Order ID 112491

January-30-14 11:45:42 AM

112491

Page 1

Item ID: D3708-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Angle
 Start Date: 1/30/14 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 1/30/14 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 1-30-14 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3708	Rev A								

100 Small Fab 0.00
100
 Small Fab Memo 0.00
 Small Fab 1- cut to length as per dwg
 2- mark, cut notch and deburr as per dwg
 3- form and bend angle as per dwg D3708 using DT9019 template

DAS
30
9-89

4
4

FF

AUG 31 2015

110 QC5- Inspect part completeness to step on W/O 0.00
110
 QC Memo 0.00
 Quality Control

DAS
38
9-89

(4)

SEP 09 2015

120 Chemical Conversion Coat per QSI005 4.1 0.00
120
 HandFinish Memo 0.00
 Hand Finishing

4 0 15-9-11 Doc

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 112491***112491***

Page 2

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Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC3- Inspect Part Finish	0.00							
130									
QC	Memo	0.00				(4)			DAS 38 9-89
Quality Control									SEP 11 2015
140	Identify as per dwg & Stock Location: 8513	0.00							
140									
Packaging	Memo	0.00							DAS 6 9-89
Packaging									SEP 14 2015
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							MCS
Quality Control									SEP 14 2015

20150914

DQA: _____ Date: _____



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Picklist Print

January-30-14 11:45:42 AM

Page 1

Work Order ID: 112491

Parent Item: D3708-3

Parent Item Name: Angle

Start Date: 1/30/14

Required Date: 1/30/14

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 08-10-31 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061TSA0.750W.063 angle .750 x .750 x .063w		Purchased	No			100	f	0.0000	1.59	6.6947368			

* M6061TSA0.750W.063

DAS 22 8-89 1203.17

128252

6.694

FF 14-03-19

ACCEPTABLE AS TESTED PER TP-D412-761-1 REV.A
AND REPORT TR-D412-761-1 REV.A.

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D3708-1 ANGLE



D3708-3 ANGLE

112491 MWS
1402-03

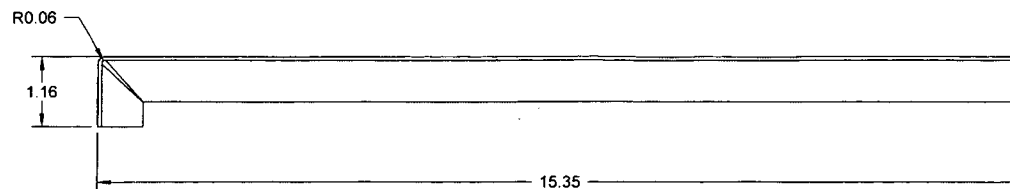
RELEASED
08/02/14

NOTES:

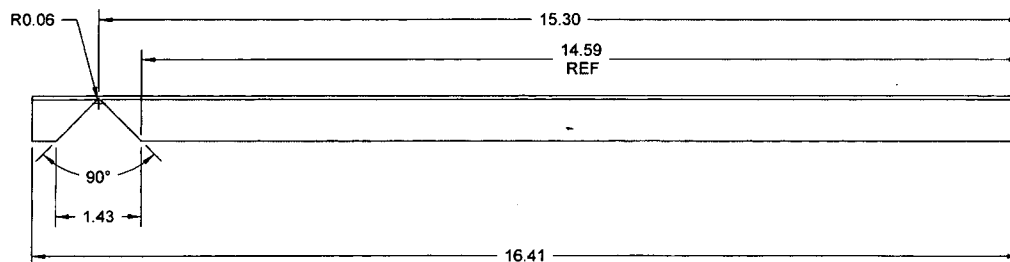
- 1) MATERIAL: 6061-T6/T6510/T6511 ALUMINUM ANGLE, 0.75 X 0.75 X 0.063
PER AMS-QQ-A-200/8
(REF. DART SPEC. M6061T6A750XW063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3708-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3708-1 = 0.16 lbs
D3708-3 = 0.14 lbs
- 8) CONTROL SHAPE PER DT9019 TEMPLATE

A	NEW ISSUE	MB	08.02.14
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.02.14		

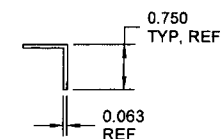
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3708	REV. A SHEET 1 OF 3
TITLE ANGLE	SCALE NTS
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D3708-1 ANGLE
(MAKE FROM D3708-1F)

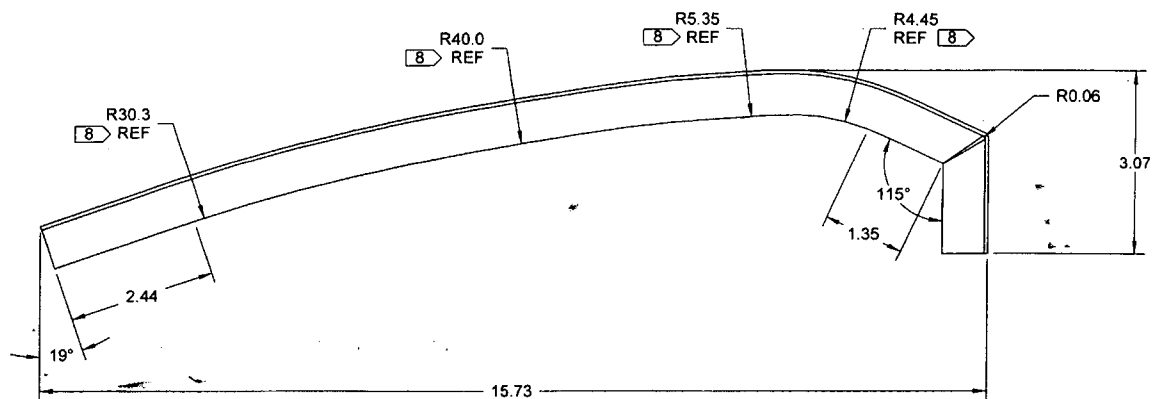


D3708-1F FLAT PATTERN

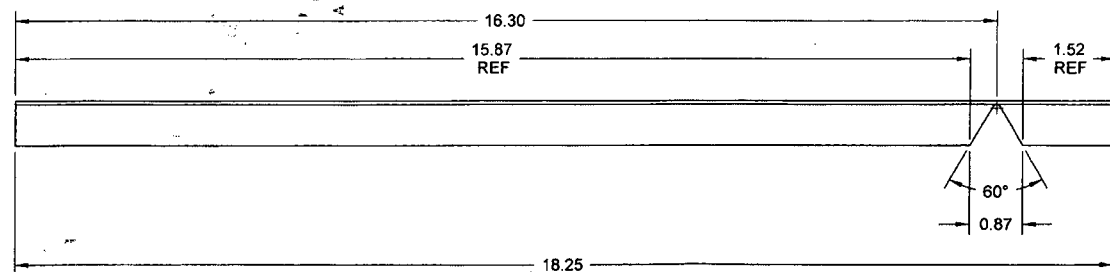


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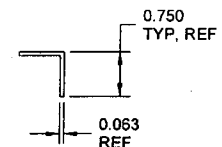
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3708	SHEET 2 OF 3
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DE APPR.		ANGLE	NTS
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D3708-3 ANGLE
(MAKE FROM D3708-3F)



D3708-3F FLAT PATTERN ANGLE



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CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3708	SHEET 3 OF 3
APPROVED		TITLE	SCALE
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